

Work Order ID 60097

June 24, 2010 9:18:48 AM



Page 1

Item ID: D2564

Accept



Setup

Start



Revision ID:

Stop



Item Name: Mounting Angle

Start Date: 6/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 20.00



Customer:

Reference:

Inv 10.06.25

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2564

Rev B1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

28.0/06/24

20



110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA276 Rev: 44 & Dwg D2564 Rev: B ☐ 2-Deburr if necessary

28.0/06/24

20



120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

28.0/06/24

20



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

DT 10/06/28

20



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *CAL*

0.00



Packaging

Memo

0.00

Packaging

10/06/29 (20)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29

10/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60097



Parent Item: D2564

Parent Item Name: Mounting Angle


Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ D ☐ 02.09.09 ☐ Re-format; Added FA276 Folio ☐ KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207  Angle Extrusion		Manufactured	No			100	f	17.5710	0.0916	1.928421			

Location

MAT07

46909

Loc Qty

17.571

17.571

Loc Code

1.9
1.9284

SP 10/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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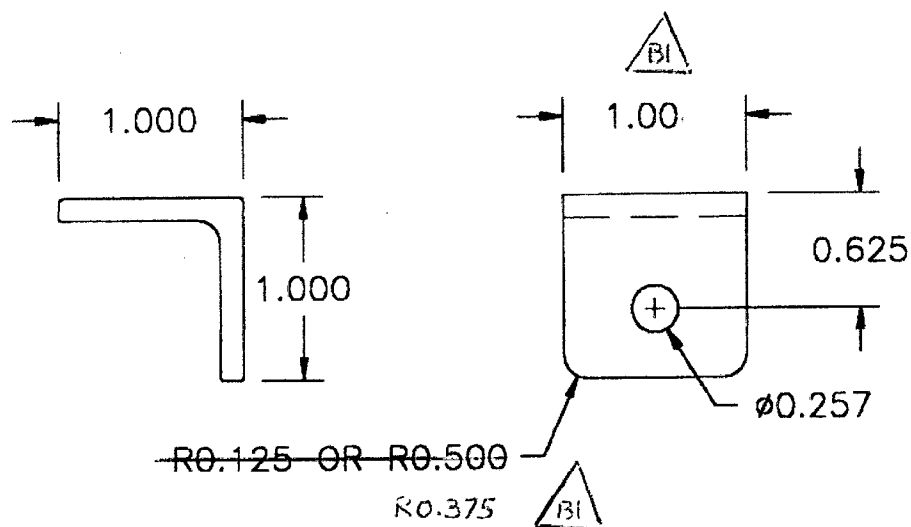
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. B
CHECKED BW	APPROVED BW	D2564	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:04:30	MOUNTING ANGLE	1:1	
B	97:05:06	MODIFIED DIMENSIONS	
BI	02.07.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

RELEASED
97/05/06 BW

w/o 60097



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM DG207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 R0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES